

Work Order ID 63795A

February-24-12 1:10:26 PM

63795A

Page 1

Item ID: D2432

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 206 (24") Bearpaw

Start Date: 2/24/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/24/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2432

Rev F3

120

0.00

120

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

B12-2-21

130

0.00

130

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburrsee wlo
80059

4 12-02-23

140

QC2- Inspect parts off machine FAI/FAIB

0.00

140

QC

Memo

0.00

Quality Control

4 12-02-23

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Item ID: D2432

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: 206 (24") Bearpaw

Stop ***NS2***

Start Date: 2/24/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/24/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00

150

QC

Memo

0.00

Quality Control

151

Identify as per dwg & Stock Location: _____

0.00

151

Packaging

Memo

0.00

Packaging

PPP 77861

4x. SP 12-02-27.

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/2/27 J

12-02-27 (H)

Picklist Print

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Page 1

Work Order ID: 63795A
 Parent Item: D2432
 Parent Item Name: 206 (24") Bearpaw

Start Date: 2/24/12
 Start Qty: 4.00

Required Date: 2/24/12
 Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 UHMW 1" Black		Purchased	No			120	sf	599.5243	3.7	14.8			

B(2-2-21)

Location	Loc Qty	Loc Code
MAT018	341.88	
120035	88.88	
120401	253	
MAT019	257.6443158	
117321	74.6	
117738	93.8	
117819	83.3	
118814	1.5	
119145	4.44431579	

(20401)

14

63775A

DART AEROSPACE LTD		Work Order: 90059
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.056	✓		vern	BT-5
B	5.500	+/-0.030	5.500	✓			
C	0.200	+/-0.030	.201	✓		depth gauge	BT-6
D	0.25 x 45°	+/-0.030	.260	✓		vern	BT-4
E	R0.250	+/-0.030	.250	✓		rod gauge	
F	0.250	+/-0.010	.254	✓		mic	118 (20)
G	0.625	+/-0.030	.632	✓		vern	BT-4
H	0.375	+/-0.010	.382	✓		mic	118 (20)
I	0.950	+0.030/0.010	.953	✓		vern	BT-4
J	19.000	+/-0.030	19.00	✓		T-type	BT-11
K	3.14	+/-0.030	3.132	✓		vern	
L	3.28	+/-0.030	3.315	✓		"	
M	Ø0.260	+0.005/-0.000	.260	✓		"	
N	Ø0.93	+/-0.030	.930	✓		"	
O	0.30	+0.030/-0.000	.300	✓		"	
P	23.750	+/-0.030	23.75	✓		T-type	
Q	7.375	+/-0.030	7.38	✓		vern	LNC-02
R	4.250	+/-0.010	4.254	✓		"	
S	2.000	+/-0.030	2.008	✓		"	
T	9.000	+/-0.010	9.006	✓		"	
U	9.000	+/-0.010	9.009	✓		"	
V	0.375	+/-0.010	.372	✓		"	

Measured by: Z	Audited by: DA	Prototype Approval: N/A
Date: 12-02-23	Date: 12/02/26	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015 KJ/RF	JF

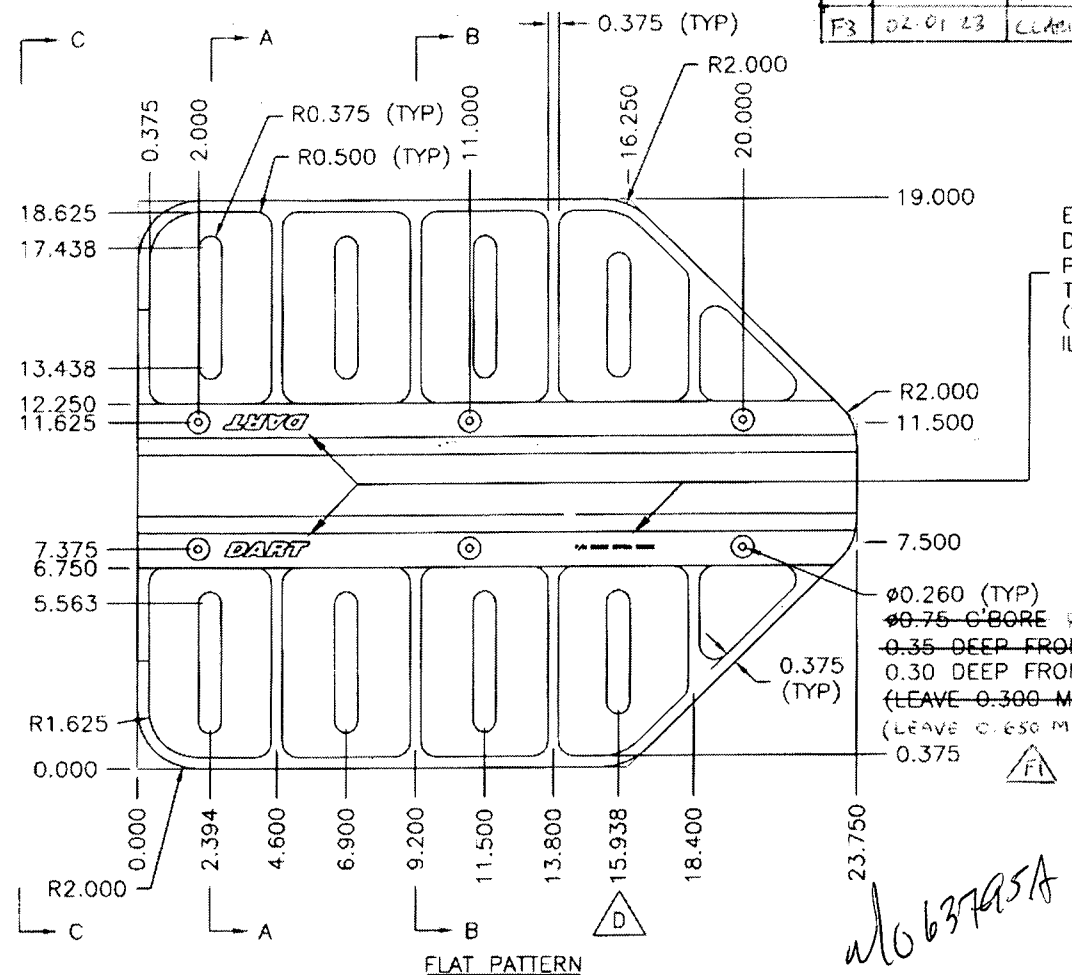
F1	95.03.13	ADD DEC 9143
F2	01.03.25	90.13 WAS 90.75 RF
F3	02.01.23	CLARIFY QORE P.M.S. RF

RELEASED
98.06.17 KJ

DART



ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



Ø0.260 (TYP)
~~Ø0.75 C'BORE~~ ~~Ø0.13 C'BORE~~
 0.35 DEEP FROM TOP (MIN.)
 0.30 DEEP FROM BOTTOM
 (LEAVE 0.300 MIN.)
 (LEAVE 0.650 MIN.)

EFFECTIVE DEOS



D2432F: FLAT BEARPAW
 D2432B: BENT BEARPAW

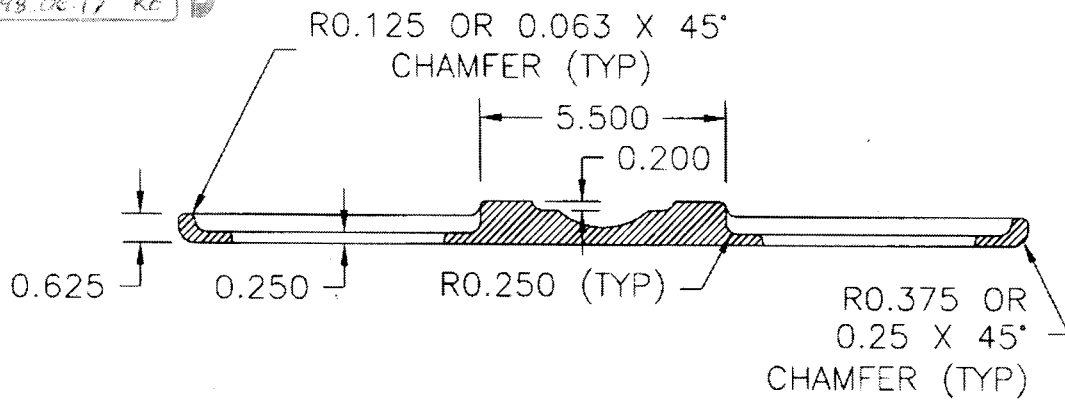
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
 1.00 THICK (MACHINE TO 0.950)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>KE</i>	
DATE 98.05.12	TITLE BEARPAW	REV. F SHEET 1 OF 2 SCALE 1:6
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

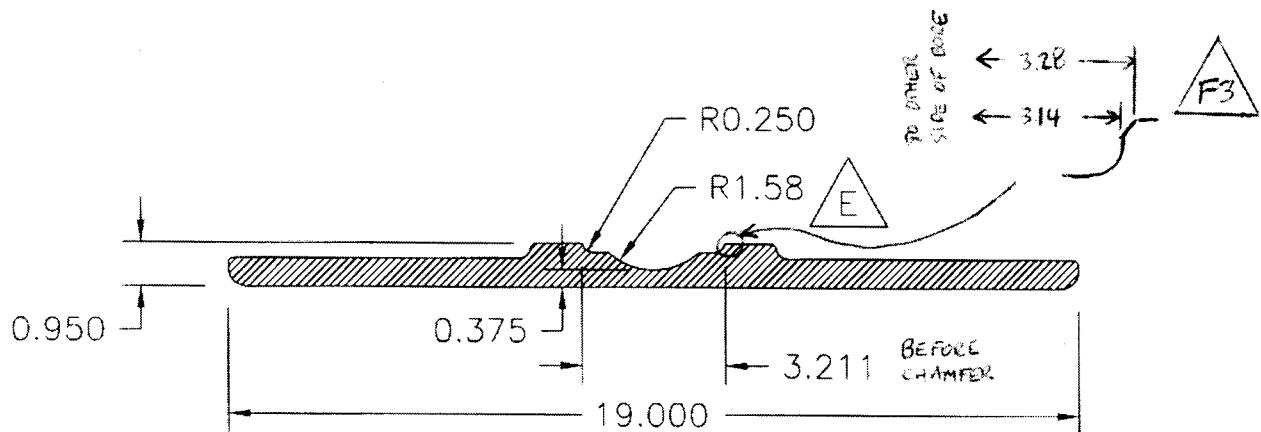


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MEY	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

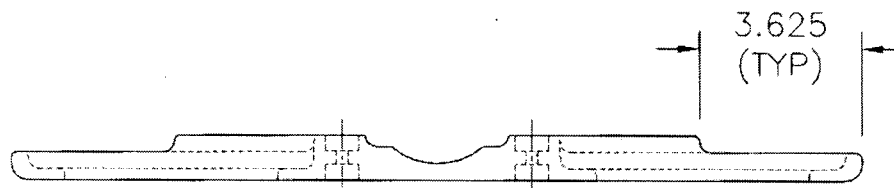
RELEASED
98.08.17 KE



SECTION A-A



SECTION B-B



SECTION C-C